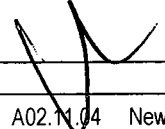


Date: Thursday, 27/03/2008 2:53:21 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ANGLE
Job Number :	38176		
Estimate Number :	10865		
P.O. Number :		Part Number :	D31711
This Issue :	27/03/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3171
First Issue :	//	Project Number :	N/A
Previous Run :	38176	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :		Due Date :	04/04/2008
Comment :	Est A02.11.04 New Issue KJ		
	Est Rev:B 08-03-27 now on water jet DD verified by:		

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



106860 IB 8-3-08



Comment: FLOW WATER JET

1-Cut as per Dwg D3171

Dwg Rev: A

Prog Rev: A

IB 8-3-08

1.5f

(32)

2-Deburr if necessary

2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-3-08



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/04/02 (32)

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

B 08/04/01 (32)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Bend as per Dwg D3171

Tumble

B 08/04/07 (32)

SB 08/04/03 (32)

Date: Thursday, 27/03/2008 2:53:21 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 38176

Part Number: D31711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/07 (X32)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 74

8/4/7

SC

(32x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



U 08-04-07

Date: Wednesday, 3/26/2008 9:54:02 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ANGLE
Job Number	: 38176		
Estimate Number	: 10865		
P.O. Number	:	Part Number	: D31711
This Issue	: 3/26/2008 S.O. No. :	Drawing Number	: D3171
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 4/4/2008 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est A 02.11.04 New Issue KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Laser cut per Dwg D3171 flat pattern D3171-1

Material: AISI 304/316 SS 0.063" thick

Material release note required

under jet

2.0

D31711F

Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Angle

3.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D3071-1T1

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3171

Deburr and Tumble

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 38176

Part Number: D31711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

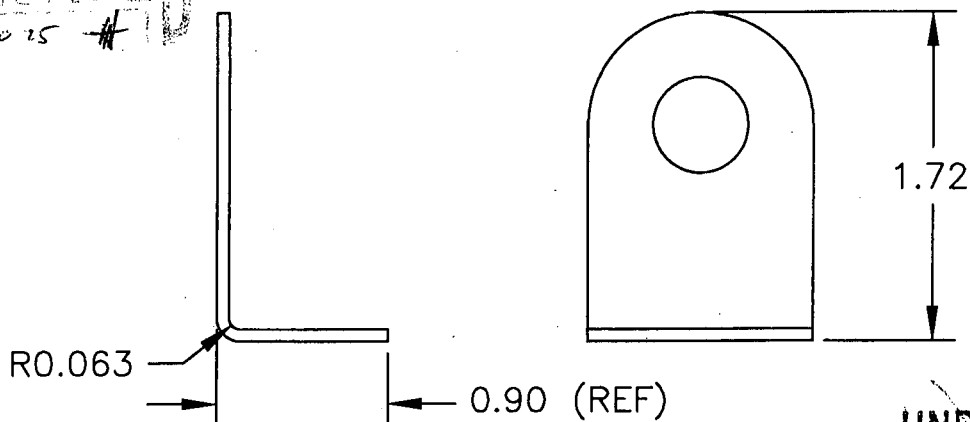
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3171	REV. A SHEET 1 OF 1
DATE 02.10.08		TITLE ANGLE	SCALE 1:1
A	02.10.08	NEW ISSUE	

RELEASED
02.10.25 #



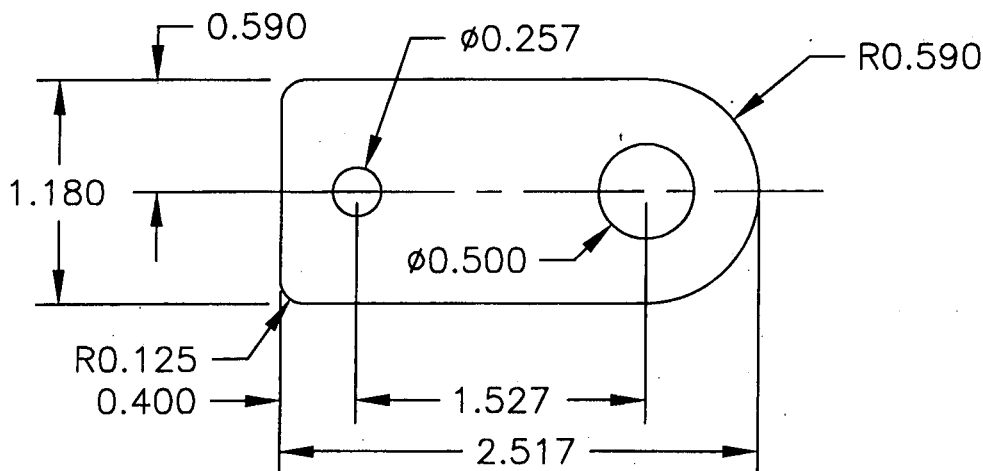
D3171-1 ANGLE

~~UNDER REVIEW~~

~~07.01.02 CB~~

~~add. by -3~~

OK
CB
-3 not
being
used



D3171-1 ANGLE FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38175

NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK
PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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